



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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Report

D5489-045
Job Sheet 198551



Part No: D5489-045

Job Qty: 12 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/19

Job Tracking No:

Due Date: 12/3/19

ck Rev.B 4/15/21

Created By: Marie Lajeunesse

Type: SOLD

Description: SIOP

Note: URF 19-1297 D5489 REV.C3 IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS REV:B 18.05.06
PRELIM B7 DD VERF:JFS IPP REV:C 18.08.15 AS PER DWG REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		12/3/19	0.17	4.00	Waterjet - Flow		<i>JRB 11/23/19</i>
110	QC 2	12 pcs		12/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S234289

Part: D5489 - 045

Job No: 198551

Serial No/Batch: S234289

Revision: C3

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/23/19

120 QC 8	12 pcs	12/3/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	ADA/ JRB 11/23/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	NOV 25 2019
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - Brake NC - B4B	12 pcs	12/3/19	0.25 0.60	Small Fab - Brake - 1 - B4B	DAS 30 DEC 01 2019
				Small Fab - Brake - 2 - B4B	9-89
				Small Fab - Brake - 3 - B4B	
140 QC 5	12 pcs	12/3/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DEC 18 2019
				QC 5 - 61	
				QC 5 - 81	
150 Automated Welding - B4B	12 pcs	12/3/19	0.00 4.00	Automated Welding - 1 - B4B	
160 QC 10	12 pcs	12/3/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	

DAS
40
9-89
DAS
82
9-89

170 QC 5	12 pcs	12/3/19	0.00 0.00	QC 10 - 43	
				QC 10 - 50	EC
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EC
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Handfinish - 4-1-Assembly- B4B <i>spray paint</i>	12 pcs	12/3/19	0.00 4.00	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	DAS
				Handfinish - 4 - 12 - B4B	41 JAN 11 2020
				Handfinish - 4 - 13 - B4B	3-89
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
190 QC 3	12 pcs	12/3/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	DAS
				QC 3 - 40	JAN 14 2020 41
				QC 3 - 19	9-89
				QC 3 - 43	
				QC 3 - 24	

				QC 3 - 61			
				QC 3 - 81			
200	Packaging 3-1 - Stock - B4B	12 pcs	12/3/19	0.00	0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B			
				Packaging 3 - 3 - B4B			
				Packaging 3 - 4 - B4B	WP001	DAS 74 9-89	JAN 17 2020
				Packaging 3 - 5 - B4B			
				Packaging 3 - 6 - B4B			
				Packaging 3 - 7 - B4B			
				Packaging 3 - 8 - B4B			
				Packaging 3 - 9 - B4B			
				Packaging 3 - 10 - B4B			
				Packaging 3 - 11 - B4B			
				Packaging 3 - 12 - B4B			
				Packaging 3 - 13 - B4B			
				Packaging 3 - 14 - B4B			
				Packaging 3 - 15 - B4B			
				Packaging 3 - 16 - B4B			
				Packaging 3 - 17 - B4B			
				Packaging 3 - 18 - B4B			
				Packaging 3 - 19 - B4B			
				Packaging 3 - 20 - B4B			
				Packaging 3 - 21 - B4B			
				Packaging 3 - 22 - B4B			
				Packaging 3 - 23 - B4B			
				Packaging 3 - 24 - B4B			
				Packaging 3 - 25 - B4B			
				Packaging 3 - 26 - B4B			
				Packaging 3 - 27 - B4B			
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
				Packaging 3 - 36 - B4B			
210	QC 21 - SA	12 pcs	12/3/19	0.00	0.00	QC 21 - SA - 21	DAS
						QC 21 - SA - 70	21
						QC 21 - SA - 53	9-89
						JAN 17 2020	

Part Op 100 - 1-Cut as per Dwg (D5489-5) Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)

150 - ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: _____

160 - (QC10- Inspect visual per QSI004- ground welds)

170 - QC5- Inspect part completeness to step on W/O)

180 - (Assemble as per dwg) COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: 521921

190 - (QC3- Inspect Part Finish)

200 - (Identify as per dwg & Stock Location: _____) LOCATION : ST606

210 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	24 sf (2 ea)	100-Waterjet - Flow - 1	5207058

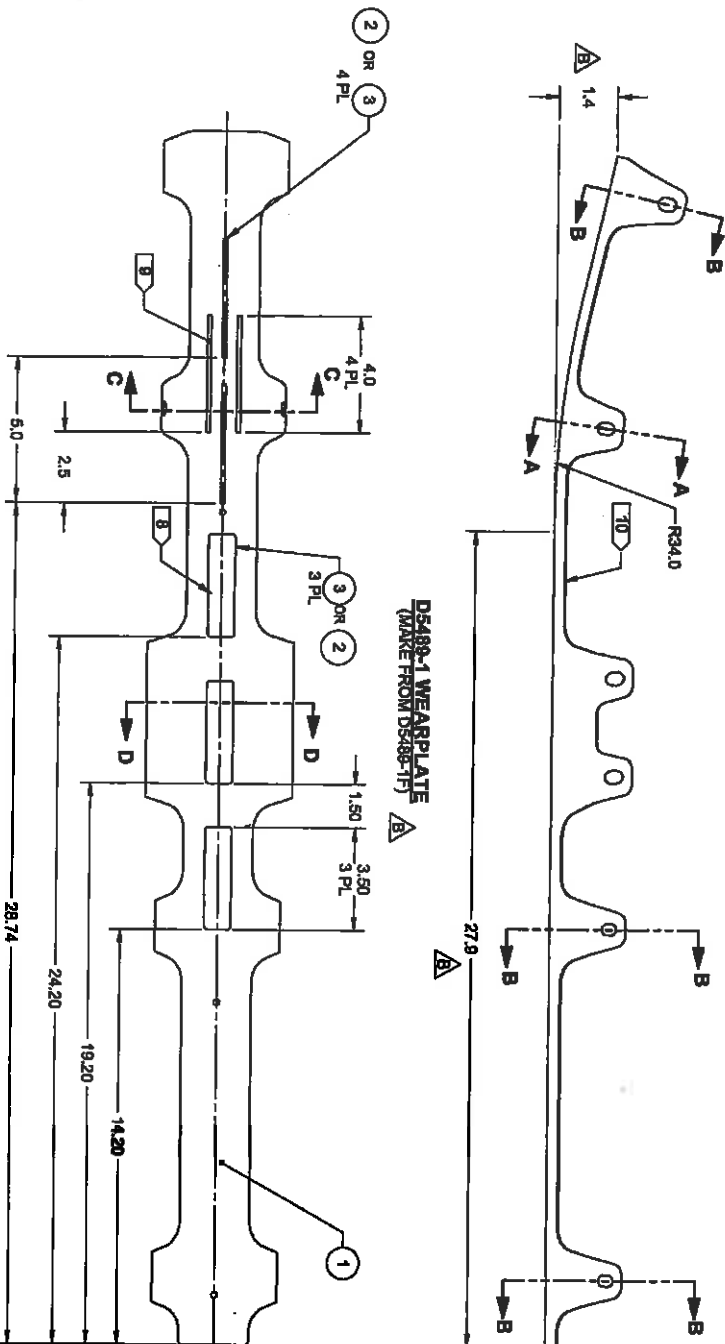
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	24	230	0
Part Specifications				
Specifications could not be found.				

Plex 11/21/19 1:24 PM Dart.lajeunesse.marie



NCR No. _____		Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:	QTY Affected :		MRB (QS1042)									
Description Work Order Deviation		Disposition											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐											
								Completed By					
								Lead hand / Supervisor					
								QC / QA Coordinator					

ITEM	QTY	P/N	DESCRIPTION
	X	DS488-041	WEARPLATE ASSEMBLY
1	1	DS488-1	WEARPLATE
2	A/R	8259	HARDCOAT SURFACING AUTOMATED WELDING
3	A/R	20598	HARDCOAT SURFACING MANUAL WELDING



DS488-041 WEARPLATE ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: PER DART OSI 044 6.1
 - 7) WEIGHT: 2.9 lbs
 - 8) WELDING: BUILD UP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER OSI 004 SECTION 4.5 (AUTOMATED WELDING) OR 20598 ROD PER OSI 004 SECTION 4.6 (MANUAL WELDING)
 - 9) WELDING: BUILD UP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER OSI 004 SECTION 4.5 (AUTOMATED WELDING) OR 20598 ROD PER OSI 004 SECTION 4.6 (MANUAL WELDING)
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART OSI 005 4.9

APPROVED		DATE		BY		DATE	
DESIGN		SAD		SAD		18.06.14	
DRAWN		SAD		SAD		17.06.10	
CHECKED		JFS		JFS			
MFG. APPR.		NO		NO			
APPROVED		NO		NO			
DE APPR.		DS		DS			
DATE		18.06.14		18.06.14			

DART AEROSPACE LTD

HANMERBURY, DUNFRA, CANADA

REV. B

SHEET 1 OF 7

SCALE

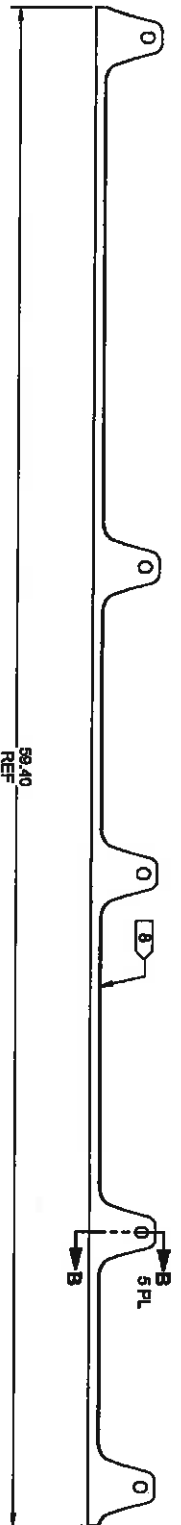
WTS

RELEASED
2018 AUG 16
ECU 18-129

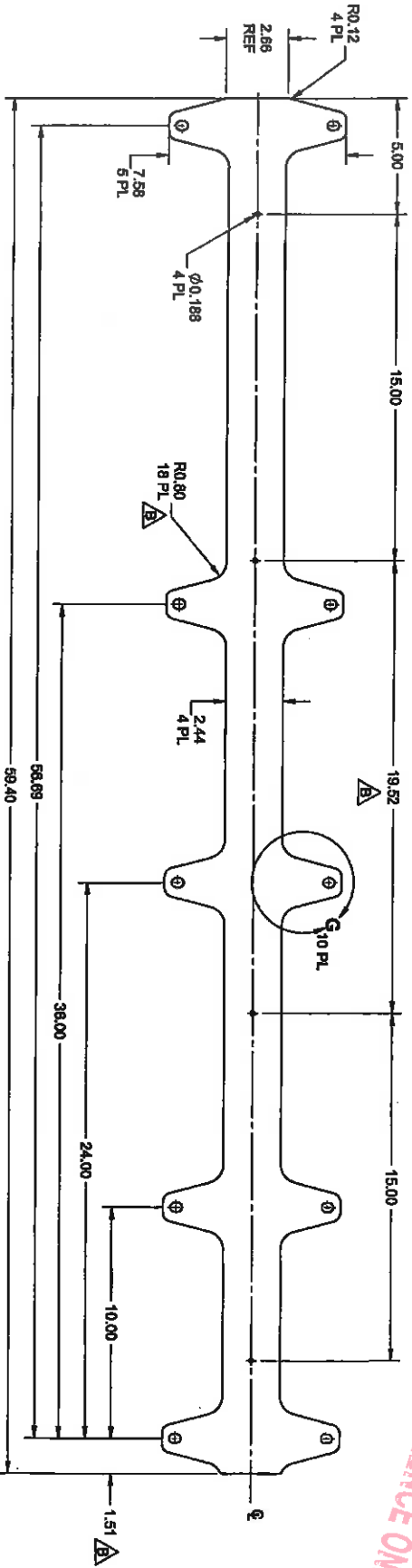
UNDER REVIEW
URF 18-129/19.11.19 (SAD)

OK
to Mark
SM/14/10/19

REFERENCE ONLY



D5489-3 WEARPLATE
(MAKE FROM D5489-3F)



D5489-3F WEARPLATE
(FLAT PATTERN)

UNDER REVIEW
URF 19-1297 19.11.19 (SAD)

RELEASE
2018 AUG 16

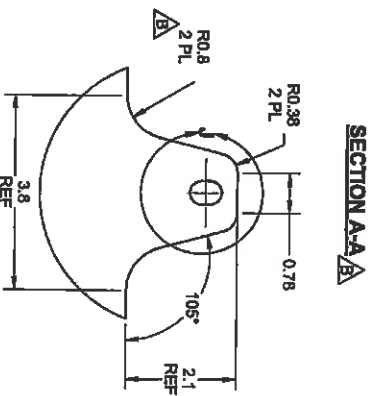
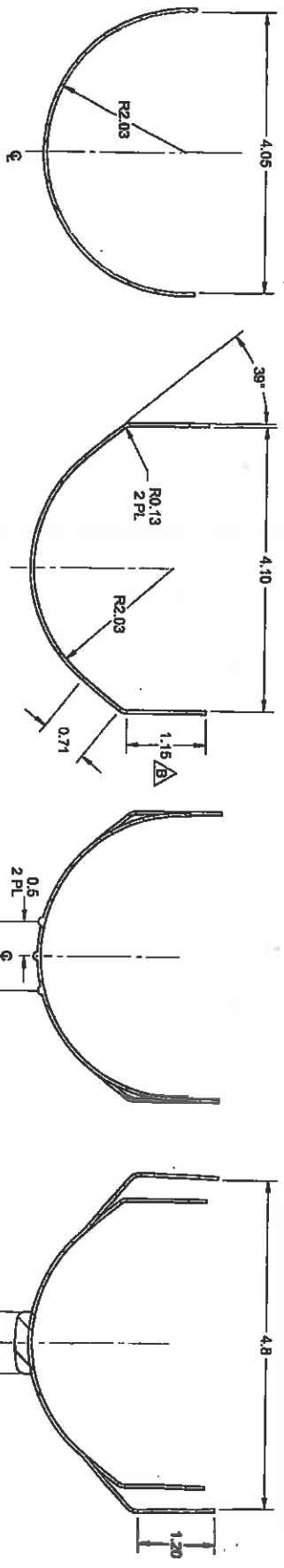
REFERENCE ONLY

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063"), PER MIL-S-5059 OR AMS 5513 (304), OR AMS 5524 (316), OR ASTM A240, OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART CSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART CSI 044 6.1
 - 7) WEIGHT: 2.7 lbs
 - 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART CSI 005 4.8

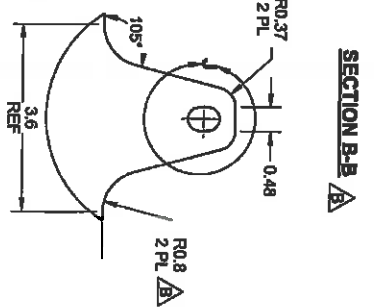
APPROVED

DESIGN	SAD	DART AEROSPACE LTD
DRAWN	SAD	HAINESLURY, ONTARIO, CANADA
CHECKED	NO	
MFG. APPR.	JFS	
APPROVED	NO	
DE APPR.	DS	
DATE	18.06.14	

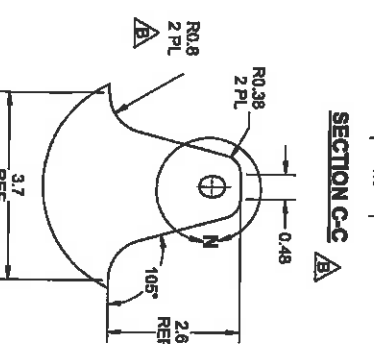
WEARPLATE
2018 AUG 16



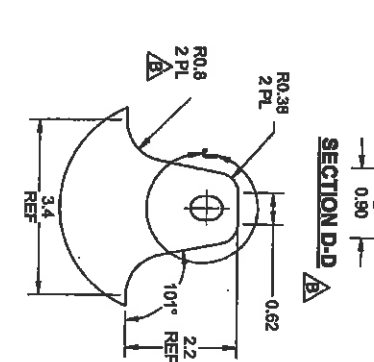
SECTION A-A /B/



SECTION B-B /B/



SECTION C-C /B/



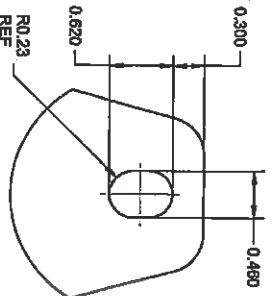
SECTION D-D /B/

DETAIL E /B/

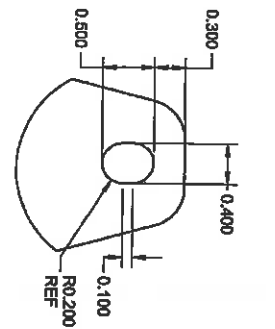
DETAIL F /B/

DETAIL G /B/

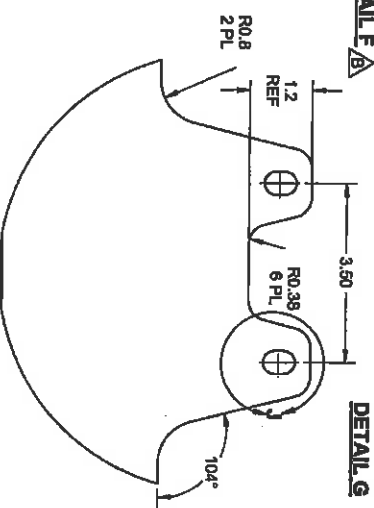
DETAIL H /B/



DETAIL J /B/



DETAIL N /B/



DETAIL M /B/

REFERENCE ONLY

RELEASED
2018 AUG 16

UNDER REVIEW
URF 18-1287 18.11.19 (SAD)

DESIGN	SAD	DART AEROSPACE LTD
DRAWN	SAD	HAWESBURY, ONTARIO, CANADA
CHECKED	NO	DRAWING NO. D5486
MFG. APPR.	JFS	REV. B
APPROVED	NO	9 SHEET 7 OF 7
DE APPR	D9	SCALE
DATE	18.08.14	NTS

APPROVED

WEARPLATE

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